

Date: Wednesday, 06/09/2006 11:05:26 AM
 User: Linda Lacelle

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	BRACKET ASSY
Job Number	28425	Part Number	D35313
Estimate Number	12523	Drawing Number	UNDER REVIEW
P.O. Number	N/A	Project Number	N/A
This Issue	06/09/2006	Drawing Revision	N/A
Prsh't Rev.	NC	Material	N/A
First Issue	N/A	Due Date	13/09/2006
Previous Run	N/A	Qty:	2
Written By	<u>RL</u>	Um:	Each
Checked & Approved By			
Comment	Est Rev:A New Issue 06-09-06 EC		

Additional Product

PRELIMINARY ISSUE

Job Number:



Seq. #:	Machine Or Operation:	Description:
1.0	M6061T6S040	6061-T6 .040 Sheet
Comment: Qty: 0.1379 sf(s)/Unit Total: 0.2757 sf(s) <u>6061-T6 .040 Sheet</u> <u>(M6061T6S040)</u> Batch: <u>MT9380</u> <u>ML 06 09 06</u>		
2.0	WATER JET	FLOW WATER JET
Comment: FLOW WATER JET 1-Cut as per Dwg D35313 Dwg Rev: <u>Prej</u> Prog Rev: <u>Prej</u> <u>ML 06 09 06</u> <u>(2)</u> <u>ML 06 09 06</u> <u>(2)</u>		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <u>ML 06 09 06</u> <u>(2)</u>		
4.0	QC8	SECOND CHECK
Comment: SECOND CHECK <u>ML 06 09 06</u>		
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr if necessary. <u>SB</u> <u>06/09/12</u> <u>(2)</u>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 01/01/04
 DQA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 06/09/2006 11:05:26 AM
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Drawing Name: BRACKET ASS'Y

Job Number: 28425

Part Number: D35313

Job Number:



Seq. #: Machine Or Operation: Description :
6.0 BRAKE NC NC BRAKE



Comment: NC BRAKE
Bend as per Dwg D3530

SB 06/09/12 ②

7.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1
Chemical Conversion Coat as per QSI 005 4.1

Am 06-09-14 ④

8.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Re 06.09.14 ②

9.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock for eng. use only.
Location:

Re 06.09.19 ②

10.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: Inspection Level 21

Re 06.09.20 ②

Job Completion



U 06.09.20

PART WENT TO HAI . PART IS NOT APPROVED AND NOT AIRWORTHY

CB 07.07.13

W/O:		WORK ORDER CHANGES					Approval Chief Eng / Prod Mgr		Approval QC Inspector		
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty				
06.05.13	6-1	Added QC S per change									
		QCS inspection			2	06.05.13	2				

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

PRELIMINARY ISSUE

DESIGN CB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3531
DATE 06.06.21		TITLE BRACKET ASSEMBLY

REV. A

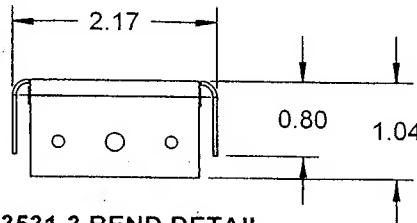
SHEET 3 OF 3

SCALE

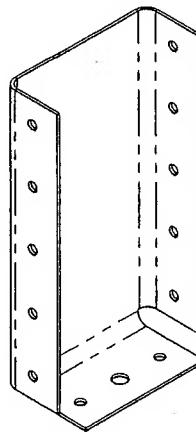
1:2

UNDER REVIEW

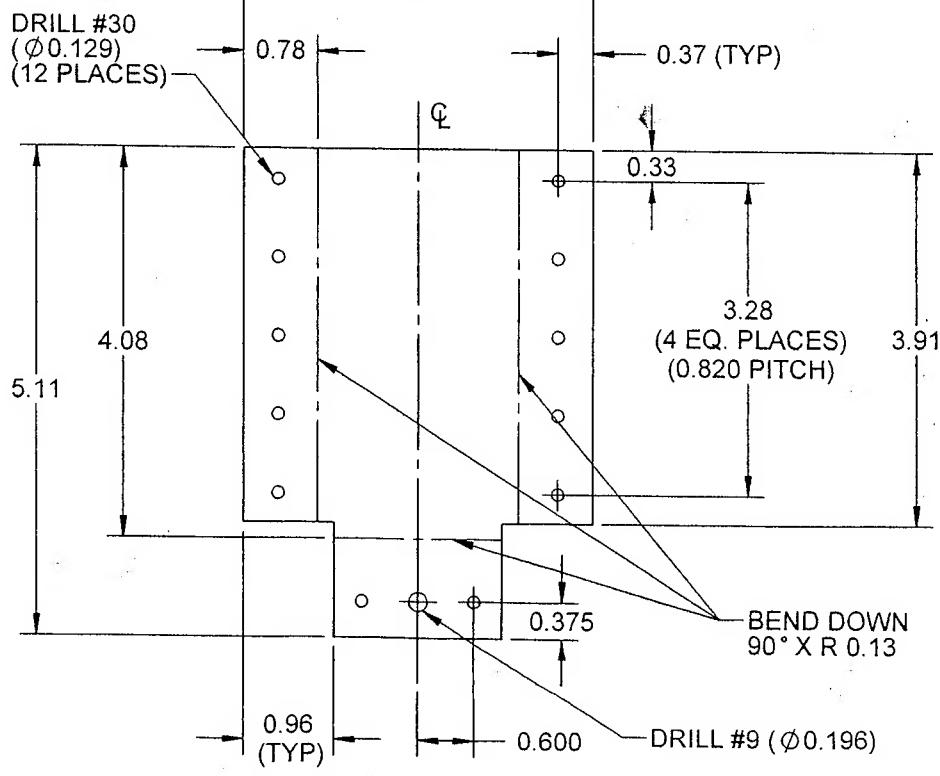
06.08.22 CB
Prototype



D3531-3 BEND DETAIL



D3531-3 BEND DETAIL



D3531-3F FLAT PATTERN

D3531-3 BRACKET FRONT PLATE

NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM (QQ-A-250/11) 0.040" SHEET
(REF. DART SPEC. M6061T6S.040)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) PART IS SYMMETRICAL ABOUT $\frac{1}{4}$

EST Done
Pros

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DART AEROSPACE LTD	Work Order:	28425
Description:	Part Number:	3531-3
Inspection Dwg:	Rev:	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

x First Article x Prototype

Measured by:	<i>M. M.</i>	Audited by:		Prototype Approval:	
Date:	<i>08.09.06</i>	Date:		Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



Corus Aluminium N.V.
A. Stocletlaan 87, 2570 Duffel - Belgium
Tel. 32 (0)15 30 21 11 - Fax (0)15 30 27 94

SPECIFICATIES: ALU SHEETS (STENCI) AA 6061-T6 AMS-QQA-250/11 AMS 4027M ASTM B209-04
AFMETINGEN : 144" X 48" X 0.04"
ARTIKEL NR.: V/0080151422

KLANT : COPPER AND BRASS SALES
CORPORATE SERVICES DIVISION
SOUTHFIELD, MI USA

UW ORDERNUMMER : PO3944 (COPPER'S PO#CC1837)
ONS ORDERNUMMER : 58848/01
DOCUMENT NUMMER : V/0080151422

ROL-
NUMMER

GEUT-
NUMMER

CHEMISCHE ANALYSE (%)

		SI	FE	CU	MN	MG	CR	TI	ZN
		MIN	0,40	0,15	0,15	0,8	0,04	0,15	0,25
		MAX	0,8	0,7	0,40	1,2	0,35		
001	7124901	0,67	0,4	0,22	0,09	1,1	0,16	0,02	0,01
602	7124901	0,67	0,4	0,22	0,09	1,1	0,16	0,02	0,01

ANDERE : ELK : MIN 0,05 MAX
TOTAAL : MIN 0,15 MAX

TEST-
NUMMER

MECHANISCHE EIGENSCHAPPEN
1 N/MM² = 1 MPa = 0,1 HBAR = 0,102 KG/MM² = 0,145 KSI
/A = ACHTER /M = MIDDEN /V = VOOR /O = RANDOM

	RM	RP02	A
	KSI	KSI	%
	MIN	MAX	
001	/A	47	39
001	/M	47	39
001	/V	47	39
002	/A	47	39
002	/M	48	40
002	/V	48	39

COPPER AND BRASS SALES

SOLD TO: 183

DATE: 12/16 QTY. 20

CUSTOMER PO: 00000004

SHIPPER NO: 4V3128

BY: 8

10/03/04